



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3163-1

Job Sheet 199565



Part No: D3163-1

Job Qty: 4 pcs

Small Qty - Space Door.

Part Name: Plate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/28/19

Job Tracking No:

Due Date: 9/27/19

Created By: Jennifer Renwick

Type: SOLD

Description: Order 13294

Note: DWG D3116 REV.F IPP B 05.10.25 Remove Powder Coat KJ/RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4		9/27/19	0.17	0.80	Waterjet - Flow	9/28/19	JRB
		pcs							
110	QC 2	4		9/27/19	0.00	0.00	QC 2 - 1		
		pcs					QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		

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Container No: S218077

Part: D3163-1

Job No: 199565

Serial No/Batch: S218077

Revision: F

Inspector:

Exp Date:

Instructions:

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120 QC 8	4 pcs	9/27/19	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	JRB 9/28/19
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	SFP 3 0 2019 40
				QC 8 - 52	9-89
				QC 8 - 23	
				QC 8 - 57	
140 Handfinish - 1-1 Chemical-B4B	4 pcs	9/27/19	0.00 0.46	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 -	

				B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150	QC 7	4 pcs	9/27/19	0.00 0.00	QC 7 - 10
					QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50
					QC 7 - 67
					QC 7 - 40
					QC 7 - 24
					QC 7 - 43
					QC 7 - 61
					QC 7 - 81
160	Packaging 3-1 - Stock - B4B	4 pcs	9/27/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Plex 8/28/19 10:20 AM Dart.Renwick.Jennifer

DAS
61
9-89

				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
170 QC 21 - SA	4	9/27/19	0.00 0.00	QC 21 - SA - 21	DAG
	pcs			QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89

OCT 02 2019

Part Op 100 - 1-Cut as per Dwg D3163 Dwg Rev: F Prog Rev: F 2-Deburr if necessary

Descriptions: 110 - QC2 Waterjet-1 (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - QC7-Inspect Chemical Conversion Coat

160 - (Identify as per dwg & Stock Location: _____)

170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.032	2024-T3 .032 Sheet	7.6000 sf (1.9 ea)	100-Waterjet - Flow - 1	SD18261

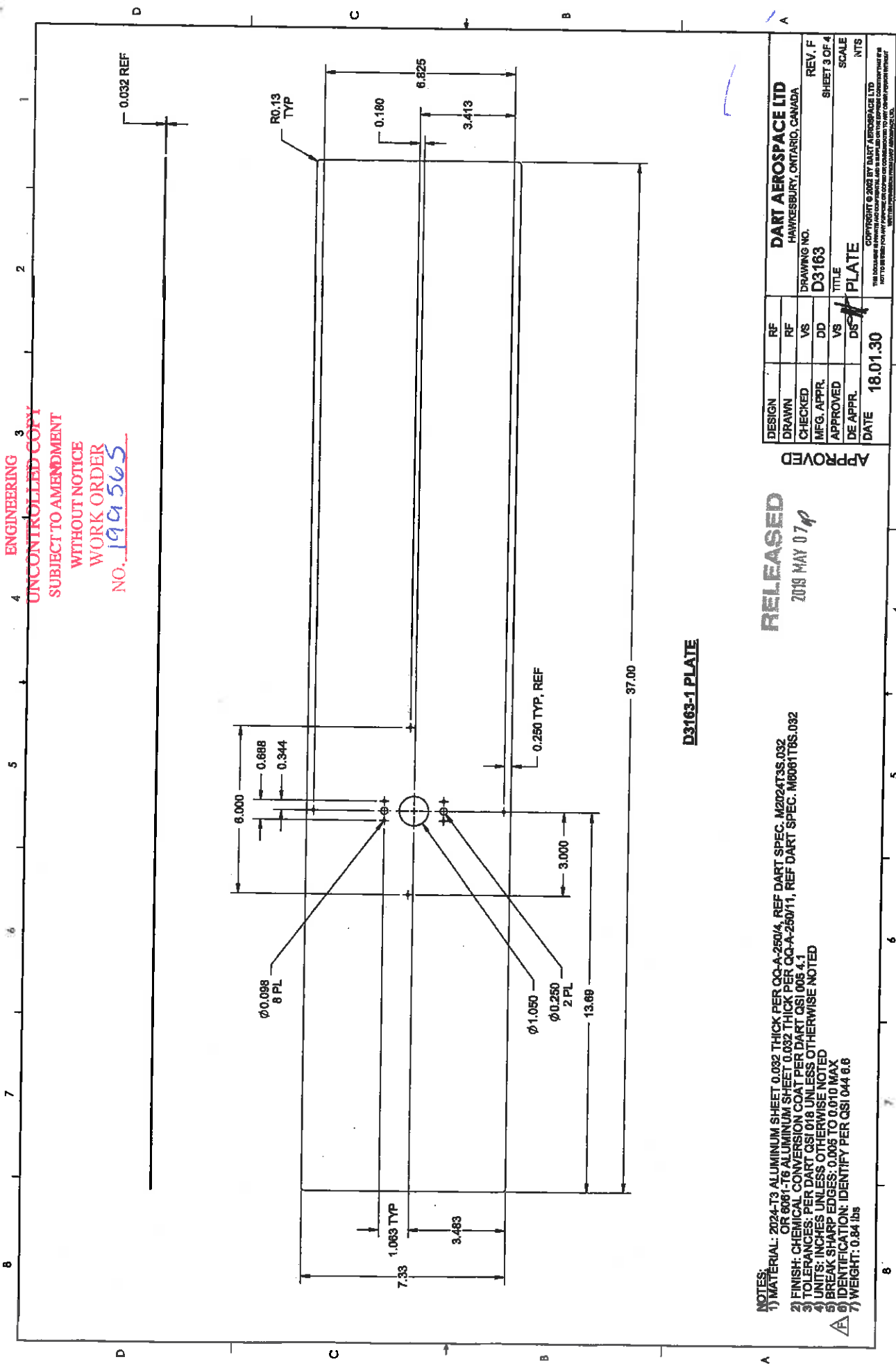
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.032	8	164	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Plate	0.098inches + 0.004 - 0.001	0.102 0.097	1.00	Diameter
2	Plate	0.250inches + 0.005 - 0.001	0.255 0.249	2.53	Diameter
3	Plate	1.050inches + 0.012 - 0.001	1.062 1.049	1.053	Diameter
4	Plate	0.250inches ± 0.010	0.260 0.240	0.252	
5	Plate	3.483inches ± 0.010	3.493 3.473	3.478	
6	Plate	3.663inches ± 0.010	3.673 3.653	3.663	
7	Plate	7.330inches ± 0.030	7.360 7.300	7.320	
8	Plate	13.690inches ± 0.030	13.720 13.660	13.690	
9	Plate	37.000inches ± 0.030	37.030 36.970	37.000	
10	Plate	3.000inches ± 0.010	3.010 2.990	3.000	
11	Plate	0.344inches ± 0.010	0.354 0.334	0.344	
12	Plate	1.063inches ± 0.010	1.073 1.053	1.063	
13	Plate	0.032inches ± 0.010	0.042 0.022	0.032	

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 199565



D3163-1 PLATE

- NOTES:
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.032 THICK PER QQ-A-250/4, REF DART SPEC. M2024T3S.032 OR 6061-T6 ALUMINUM SHEET 0.032 THICK PER QQ-A-250/11, REF DART SPEC. M6061T6S.032
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 006 4.1
 - 3) TOLERANCES: PER DART QSI 019 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.006 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
 - 7) WEIGHT: 0.84 lbs

RELEASED
2019 MAY 07

APPROVED

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	VS	DRAWING NO. D3163
MFG. APPR.	DD	REV. F
APPROVED	VS	SHEET 3 OF 4
DE APPR.	DS	TITLE PLATE
DATE	18.01.30	SCALE NTS

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